



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3506-3

Job Sheet 179704



Part No: D3506-3

Job Qty: 12 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/21/18

Job Tracking No:

Due Date: 7/18/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP Rev:A New Issue 06-05-31 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	12 Ea	7/18/18	7/18/18	0.00	0.00	Start Up Waterjet		18/07/16
100	Waterjet	12 pcs	7/18/18	7/18/18	0.00	0.43	Waterjet1		18/07/16
110	QC	12 pcs	7/18/18	7/18/18	0.00	0.00	QC2 Waterjet-2		18/07/16
120	CNC Vertical Machining	12 pcs	7/18/18	7/18/18	0.00	0.86	HAAS1-3		18/08/11
130	QC	12 pcs	7/18/18	7/18/18	0.00	0.00	QC2 Machining-2		18/08/11
140	QC	12 pcs	7/18/18	7/18/18	0.00	0.00	QC8 Machining-2		18/08/11
150	Small Fab	12 pcs	7/18/18	7/18/18	0.00	0.14	Small Fab-4		18/08/11
160	QC	12 pcs	7/18/18	7/18/18	0.00	0.00	QC5		18/08/11
170	HandFinish	12 pcs	7/18/18	7/18/18	0.00	0.20	HandFinish1		18/08/11
180	QC	12 pcs	7/18/18	7/18/18	0.00	0.00	QC7-2		18/08/11
190	Packaging	12 pcs	7/18/18	7/18/18	0.00	0.00	Packaging3-1		18/08/11
200	QC21-SA	12 Ea	7/18/18	7/18/18	0.00	0.00	QC21		18/08/11

Part Op 100 - 1-Cut as per Dwg D3506 Dwg Rev: A Prog Rev: A 2-Deburr if necessary

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - Machine as per Folio FA640 and Dwg D3506

130 - QC2- Inspect parts off machine FAI/FAIB

140 - QC8- Inspect parts - second check

150 - C'sink as per Dwg D3506 (On Flat side)

160 - QC5- Inspect part completeness to step on W/O

170 - Chemical Conversion Coat per QSI005 4.1

180 - QC7-Inspect Chemical Conversion Coat

190 - Identify as per dwg & Stock Location: LG001

200 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.100	6061-T6 .100 Sheet	.0936 sf (.0078 ea)	90-Start up Operation	5025678

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.100	0	44	0

Part Specifications

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____	DISPOSITION Rework ☐ Scrap ☐ _____	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Cross tube ☐ Small Fab ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Backstore/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																																																																		
Description \ Dart Aerospace Ltd. 1270 Aberdeen Street Hawkebury, ON K6A 1K7 CANADA TEL: 1 813 832-5200 Email: sales@dartaero.com www.dartaerospace.com DART AEROSPACE Container No: S091971 Part: D3506-3 Job No: 179704 Serial No/Batch: S091971 Revision: Inspector: Exp Date: Instructions: Date: 07/18/18		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																																																																																																		
<table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th colspan="2" style="text-align: left;">Root Cause</th> <th colspan="2"></th> <th colspan="2"></th> <th colspan="2"></th> <th colspan="2"></th> </tr> </thead> <tbody> <tr> <td>Environment</td><td>☐</td> <td>No Re-verif.</td><td>☐</td> <td>Bending</td><td>☐</td> <td>Set-up</td><td>☐</td> <td>/Surge</td><td>☐</td> </tr> <tr> <td>Design</td><td>☐</td> <td>Operator</td><td>☐</td> <td>Centre Not Concentric</td><td>☐</td> <td>BOM/Route</td><td>☐</td> <td>am</td><td>☐</td> </tr> <tr> <td>Doc/Data</td><td>☐</td> <td>Offset/Setup</td><td>☐</td> <td>Cracks</td><td>☐</td> <td>Broken/Damage/Defect</td><td>☐</td> <td>Grain</td><td>☐</td> </tr> <tr> <td>Equip/Tooling</td><td>☐</td> <td>Supplier</td><td>☐</td> <td>Crimp/Kink/Ripple/Wave</td><td>☐</td> <td>Inspection Incomplete/Unqualified</td><td>☐</td> <td>Weld</td><td>☐</td> </tr> <tr> <td>Handling/Pre</td><td>☐</td> <td>Training</td><td>☐</td> <td>Cuffs</td><td>☐</td> <td>Contamination</td><td>☐</td> <td>Wrong Stock Pulled</td><td>☐</td> </tr> <tr> <td>Material</td><td>☐</td> <td>Use for Testing</td><td>☐</td> <td>Crushing</td><td>☐</td> <td>Countersink</td><td>☐</td> <td>Out of Sequence</td><td>☐</td> </tr> <tr> <td>Internal Transport</td><td>☐</td> <td>Poor Information</td><td>☐</td> <td>Heat Treat</td><td>☐</td> <td>Cut Too Short</td><td>☐</td> <td>Off-set</td><td>☐</td> </tr> <tr> <td>Tribal Knowledge</td><td>☐</td> <td>Rushing</td><td>☐</td> <td>Wave/Twist in Tube</td><td>☐</td> <td>Instructions Incomplete/Unclear</td><td>☐</td> <td>Mislabeled</td><td>☐</td> </tr> <tr> <td>LOA</td><td>☐</td> <td>Product Improvement</td><td>☐</td> <td>Marks/Chatter</td><td>☐</td> <td>Drill Holes</td><td>☐</td> <td>Fit/Function</td><td>☐</td> </tr> <tr> <td>Substation</td><td>☐</td> <td>Process Improvement</td><td>☐</td> <td colspan="6" rowspan="3"></td> </tr> <tr> <td>Past Expiry Date</td><td>☐</td> <td>Manufacturing Process</td><td>☐</td> </tr> <tr> <td>Misidentified</td><td>☐</td> <td>Past Due</td><td>☐</td> </tr> <tr> <td colspan="10" style="text-align: center;">OTHER : _____</td> </tr> </tbody> </table>					Root Cause										Environment	☐	No Re-verif.	☐	Bending	☐	Set-up	☐	/Surge	☐	Design	☐	Operator	☐	Centre Not Concentric	☐	BOM/Route	☐	am	☐	Doc/Data	☐	Offset/Setup	☐	Cracks	☐	Broken/Damage/Defect	☐	Grain	☐	Equip/Tooling	☐	Supplier	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Weld	☐	Handling/Pre	☐	Training	☐	Cuffs	☐	Contamination	☐	Wrong Stock Pulled	☐	Material	☐	Use for Testing	☐	Crushing	☐	Countersink	☐	Out of Sequence	☐	Internal Transport	☐	Poor Information	☐	Heat Treat	☐	Cut Too Short	☐	Off-set	☐	Tribal Knowledge	☐	Rushing	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Mislabeled	☐	LOA	☐	Product Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Fit/Function	☐	Substation	☐	Process Improvement	☐							Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	OTHER : _____									
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Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	0.128inches + 0.005 - 0.001	0.133 0.127	0.129"	
2	Doubler	0.277inches + 0.006 - 0.001	0.283 0.276	0.278"	
3	Doubler	0.750inches ± 0.010	0.760 0.740	0.748"	
4	Doubler	1.500inches ± 0.010	1.510 1.490	1.500"	
5	Doubler	0.375inches ± 0.010	0.385 0.365	0.375"	
6	Doubler	0.750inches ± 0.010	0.760 0.740	0.748"	
7	Doubler	0.250inches ± 0.010	0.260 0.240	0.250"	
8	Doubler	0.098inches ± 0.010	0.108 0.088	0.099"	

DSP 18/08/11 Plex 6/21/18 7:16 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition		Completed By																	
				Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																
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